

## Chapter 6

### MACHINE SETUP (MAIN ADJUSTMENTS)

#### 6.1 MACHINE SETUP

Some manual adjustments need to be done to put the machine in running conditions according to the different formats and thicknesses of the signatures to be sewn.

The adjustments inside the protected areas must always be performed with the machine stopped and the guards open. Always fix carefully the screws and other locking parts after adjustments.

#### 6.2 SEWER MAIN ADJUSTMENTS

The machine needs to be prepared to make it work properly. Needles, hooks, punches and loop carriers must be assembled and the position of some machine parts needs to be adjusted according to the size of the signatures.

##### 6.2.1 Needles and hooks preparation

Define the number of stitches to be used and their position on the back of the signatures according to the head/tail format of the signature. Insert the needles in their centers and the hooks in the holder rotating heads. Afterwards, make sure that needles and hooks are in the exact position and push them deep down in their seat. Finally, carefully fasten the fixing screws.

##### 6.2.2 Sewing thread preparation

Choose a thread suitable for the book.

1. Pass the thread from front and rear shuttles through pole holes located above the shuttles.
2. Pass the thread through the tension elements placed in front of the shuttle table, in front of the mobile shaft folded in "omega" and opposite the fixed straight shaft post below.
3. Insert the thread under the elements figuring the thread tension located immediately above the buttons, then through the holes of the button leading bar.
4. Pass the thread around the switching posts located below the buttons and below the fixed spindle placed below the thread tensioning springs, then through the loop of the thread tensioning springs. Finally, insert the thread through the holes of the needle holder fixed heads, and pass it into the eye of the needle.